Be sure this information reaches the operator.
You can get extra copies through your supplier.

L-11-618-B
April, 1981

OPERATING INSTRUCTIONS for

PUROX TWO-STAGE REGULATORS

Regulator		Gas Service	Inlet Connection CGA No.	Outlet Connection CGA No.†	Max. Delivery Pressure psig (kPa)	Pressure Gauges psig (kPa)	
Model	Part No.					Cylinder	Delivery
R-2040 R-2047	54L01 54L08	Acetylene	300 510	023	15 (103)	400 (2760)	30 (207)
R-2049 R-2050	54L10 54L11	Oxygen	540	022	75 (517) 200 (1380)	4000 (27600)	100 (690) 400 (2760)
R-2051 R-2052 R-2053	54L12 54L13 54L14	Inert Gases	580	032	15 (103) 75 (517) 200 (1380)	4000 (27600)	30 (207) 100 (690) 400 (2760)
R-2042 R-2043	54L03 54L04	Carbon Dioxide	320	032	75 (517) 200 (1380)	4000 (27600)	100 (690) 400 (2760)
R-2045 R-2046	54L06 54L07	Hydrogen	350	023	75 (517) 200 (1380)	4000 (27600)	100 (690) 400 (2760)
R-2056	54L17	Industrial Air	590	033	200 (1380)	4000 (27600)	400 (2760)

†CGA-022 (formerly "B" Oxygen) - 9/16–18 RH male
CGA-023 (formerly "B" Fuel Gas) - 9/16–18 LH male
CGA-032 (formerly "B" Inert Gas) - 5/8–18 RH female
CGA-033 (formerly "B" Air) - 5/8–18 LH female

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IMPORTANT

These INSTRUCTIONS are for experienced operators. If you are not fully familiar with the principles of operation and safe practices for oxy-fuel gas equipment, we urge you to read Linde's free booklet "Precautions and Safe Practices," Form 2035. The same information appears in the "Oxy-Acetylene Handbook" which may be purchased from any Linde Distributor. Do NOT permit untrained persons to install, operate, or maintain this equipment. Do NOT attempt to install or operate this equipment until you have read and fully understand these Instructions. If you do not fully understand these Instructions, contact your supplier for further information.

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UNION CARBIDE WELDING PRODUCTS

IMPORTANT: For packing purposes, the pressure-adjusting screw of the regulator may be either turned in or packed separately. If installed in regulator, back out screw (turn counterclockwise) until it turns freely. If packed separately, install the screw in the regulator cap and turn it in (clockwise) only one or two turns.

TO CONNECT:

1. Open the cylinder valve slightly, for an instant. (This is termed 'cracking the valve'.) This will blow out dust or dirt that may have collected in the valve outlet. BE SURE to keep your face away from the valve outlet to protect your eyes from dust or dirt.

   Never crack a fuel gas valve near sparks, flames, or any other possible source of ignition.

   Hydrogen will sometimes ignite spontaneously upon expanding into the atmosphere. Be ready to close the valve immediately in case such ignition should occur.

2. MAKE SURE the regulator pressure-adjusting screw is released by turning it counterclockwise until it turns freely.
3. Attach the regulator to the valve and tighten the connection nut with a wrench.
4. Open the cylinder valve SLOWLY. (Open acetylene cylinder valves no more than 1-1/2 turns.)

   Never stand in front of or behind the regulator when opening the valve. Always stand to one side.

5. Attach the hose to the regulator outlet and to the equipment with which it is to be used. Tighten the connecting nuts with a wrench.

TO ADJUST PRESSURE:

1. To increase delivery pressure, turn the pressure-adjusting screw clockwise. To decrease delivery pressure, turn the pressure-adjusting screw counterclockwise.
2. When making the initial delivery pressure adjustment, all valves downstream of the regulator must be open or you will not get a true working-pressure on the delivery-pressure gauge.

IMPORTANT: Before starting operations, test all connections with Leak Test Solution that is suitable for oxygen service, such as P/N 998771 (8 oz. container). Correct any leaks before starting work. Testing should be performed after torch or other gas-using device has been properly connected, and with maximum delivery pressure (see Table) in the delivery line.

TO RELEASE PRESSURE:

If operations are to be stopped for a half-hour or more, you should release all pressure from regulator. To do this, proceed as follows:

1. Close the cylinder valve.
2. Open all valves downstream of the regulator.
3. Wait until the pressure has dropped to zero, then turn the pressure-adjusting screw counterclockwise until it turns freely.

NOTE: If a regulator is to be out of use for a few days or more, turn in the pressure-adjusting screw enough to move the valve stem off the seat. When the regulator is returned to use, BE SURE to back off the pressure-adjusting screw until it turns freely before pressure is admitted to the regulator.

INLET FILTER MAINTENANCE:

Each regulator is equipped with a porous metal inlet filter, P/N 71Z33, pressed into the regulator inlet nipple. No regulator should be connected to a cylinder valve unless it contains this filter. You can replace the filter if you have reason to do so. To remove a filter, insert a No. 1 'EZY-OUT' or a No. 6 wood screw (about 2-in. long) into the filter and pull it out. Press the new filter into the nipple with a 1/4-in. round metal rod.

REPAIR SERVICE:

Regulators in need of repair should be returned to your distributor of UNION CARBIDE Welding Products, or to any authorized LINDE repair station.

If you have your own properly-equipped and staffed repair facility, repair parts information for this regulator is available on request to your distributor or any LINDE sales region office. Request Form 11-626, which covers all regulators listed on this sheet.

UNION CARBIDE **WELDING PRODUCTS**

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